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D5526-1

Job Sheet 181990



Part No: D5526-1

Job Qty: 10 ea

Part Name: Upper Hose Protector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/15/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5526 REV.A ****ONE BLANK MAKE TWO PART**** IPP REV:A 17.04.13 NEW ISSUE DD VERF:JFS IPP
REV:B 17.05.04 as per dwg rev. a2 DD VERF:JFS IPP REV:C 17.12.15 AS PER REV.A11 DD VERF:JFS IPP
REV:D 18.02.26 AS PER DWG REV.A DD VEF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Machining-4		VHS 18/9/10
100	Bandsaw	10 pcs	8/31/18	8/31/18	0.00	0.50	Bandsaw1		
110	CNC Vertical Machining	10 pcs	8/31/18	8/31/18	0.00	1.00	HAAS1-6		
120	QC	10 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Machining-5		
130	QC	10 pcs	8/31/18	8/31/18	0.00	0.00	QC8 Machining-5		
180	Packaging	10 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-2	57/67 SEP 13 2018	SL 18-9-11
190	QC21-SA	10 Ea	8/31/18	8/31/18	0.00	0.00	QC21		DAS 9-89

Part Op 100 - CUT BLANK AT 5.90" ****ONE BLANK MAKE TWO PART****
Descriptions: 110 - 1-Machine as per folio FB559 FOLIO REV: _____ DWG REV: _____ 2-Deburr
SEP 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINB1.000X4.000	Delrin Bar	2.4600 ft (.246 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINB1.000X4.000	2	14	0

Part Specifications

Specifications could not be found.

Plex 8/15/18 10:51 AM Dart.lajeunesse.marie

MDELINB1.000X04.000
S030560

DART AEROSPACE LTD		Work Order:	181990
Description:		Part Number:	D5526-1
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.13	±0.030 ±0.030	0.130	✓		Vern CHT-01	
L15		1.153	✓			
Ø0.130		0.130	✓			
1.90		1.907	✓			
Ø0.25		0.254	✓			
Ø0.27		0.265	✓			
Ø2.00		2.00	✓			
Ø0.06		0.06	✓			
Ø0.63		0.63	✓			
10°	±0.5	10°	✓			
Ø0.91	+0.030	0.91	✓			
Ø0.25		0.253	✓			
Ø0.700		0.706	✓			
3.00		3.00	✓			
4.00		3.998	✓			
1.36		1.344	✓			
Ø0.080	±0.010	0.085	✓			
Ø0.030		0.03	✓			
Ø0.250		0.250	✓			
Ø0.33		0.331	✓			

Measured by:	VHJ	Checked by:	JK	QC Inspector:	
Date:	18/9/10	Date:	18-9-11	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				